

Date: Monday, 2/11/2008 2:14:35 PM  
 Drawn: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR  
 Job Number : 37362  
 Estimate Number : 10877  
 P.O. Number : Part Number : D205711013  
 This Issue : 2/11/2008 S.O. No. : Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : N/A  
 Previous Run : 36821 Material : N/A  
 Written By : Due Date : 3/14/2008 Qty: 1 Um: Each  
 Checked & Approved By : LT 08 02 11  
 Comment : Est Rev: A 04.11.09 New issue KJJ/LM

## Additional Product

Job Number:



Seq. # Machine Or Operation Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5671 to Eagle Copters

"Assembly of D205-711-013 Door Assembly

Send a copy of this IPP

LT 08 02 11 ①

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

LT 08-003302

LT 08 02 11 08.09.10

4.0 D412711101 Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

LT 08-001222

LT 08 02 11 08.09.10

5.0 D205711113 Wiring Harness, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

1 D205-711-113 Wiring Harness, 205

Attach serviceable tags

Batch  
W/043667.11.1

LT 08 02 11

08.09.10

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37302

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

EA2046915205

Instrument Panel, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 EA20469-15-205 Instrument Panel, 205 44499

Attach serviceable tags

*[Signature]*

08.09.10

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door LT 08-003302

Attach serviceable tags

*[Signature]*

08.09.10

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window LT 08-00122Z

1 EA20469-05 Rubber Strip LT 06-011664

1 EA20469-06 Aluminum Strip Deleted

1 EA20469-07 Angle 44499

1 EA20469-08 Placard 44499

1 EA20469-10 Rear Rib Assy 44499

1 EA20469-11 Angle 44499

1 EA20469-12 Fwd Rib 44499

1 EA20469-13 Window 44499

1 EA20469-14 Window Retainer 44499

1 EA20469-16 Armrest Assy 44499

1 EA20469-17 Angle 44499

1 EA20469-18 Door Inner Skin 44499

1 EA20469-21 Door Cover Panel 44499

2 EA20469-23 Link 44499

1 EA20469-24 Rod 44499

1 EA20469-25 Arm Assy 44499

Material Certification / Proof of Traceability / Certificate of Conformity required

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37382

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt 07-18790

22 AN3-4A Bolt 08-001209

24 AN3-7A Bolt 07-017476

6 AN960-6L Washer 05-022623

90 AN960-10L Washer 06-018522

34 CR3242-4-2 Rivet 08-001645

135MS20426AD3-3 Rivet 07-006985

140MS20426AD4-3 Rivet 05-002460

25 MS20470AD3-3 Rivet 07-007189

90 MS20470AD4-3 Rivet 07-015056

24 MS21042L3 Nut 08-002039

2 MS21042L06 Nut 06-014775

13 MS21069L3 Nut Plate 08-001202

8 MS21069L08 Nut Plate 07-018940

1 MS21071L3 Nut Plate 08-002216

1 MS21071L08 Nut Plate 08-001935

9 MS21075L3 Nut Plate 05-004764

2 MS24677-12 Screw 05-011931

6 MS27039-1-09 Screw 07-0141232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*[Signature]*

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

08.09.10

9.0

QC5

INSPECT WORK TO CURRENT STEP



*[Signature]*

Comment: INSPECT WORK TO CURRENT STEP

08.09.10

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Darl Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37362

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

PACKAGING 1

PACKAGING RESOURCE #1



*AS*  
08.01.10

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*AS*

Comment: INSPECT 100% KITS FOR COMPLETENESS

08.01.10

12.0

PACKAGING 1

PACKAGING RESOURCE #1



*AS*  
July 7/08

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-711-013

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Work Order Number: 44503 V/Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.***Squawk: 2.1**Discrepancy:

Modify Door to Vertical Reference Door as per DART STC SH92-54 (Bell 205)

Resolution:

Vertical reference door modified iaw dart STC SH92-54 (bell 205) on service order P/O 081000838. Assembled door and installed window.

**2.1** Work Done By: Richard Semeniuk***The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*****AMO 6-81**

Signature: Colin Gould on 4/9/2008

Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-125	L/H DOOR ASSEMBLY	LT-08-003302	Core	1
BELL212-L	BUBBLE WINDOW ILO	LT-08-001222	New	1
	EA20469-03 and D412-711-101			
412-110-103	DOOR HANDLE W/LOCK	LT-08-003510	New	1
204-030-481-001	ROD ASSY	LT-08-004809	New	1
204-030-499-005	ROLLER ASSY	LT-08-004153	New	2
204-030-853-037A	SKIN ASSY	LT-08-004296	New	1
204-031-762-001	SPRING ASSY	LT-07-017524	New	2
204-031-762-002	SPRING ASSY	LT-07-011196.3	Inspected	1
204-031-762-002	SPRING ASSY	LT-07-011196.4	Inspected	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

**Squawk: 2.2**Discrepancy:

Paint Door

Resolution:

Painted as required

**2.2** Work Done By: Colin Gould

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
 \*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

**EAGLE COPTERS MAINTENANCE LTD.**

823 McTAVISH ROAD N.E., CALGARY, ALBERTA T2E 7G9

D.O.T. APPROVAL No. **6-81**

Nomenclature *Door, Copilot*  
Manufacturer *BHT* Type/Model *205*  
Part No. *204-030-853-125* Serial No. *7/K*  
Total time: *7/K* Work Order *44503*  
T.S.O. *7/K* Overhaul ☐ NEW ☐  
Inspected ☐ Tested ☐ Repair ☐ Modification ☒ Removal ☐  
Previous Certification *CGEEC*

The maintenance described has been performed in accordance with the applicable standards of airworthiness.

*Apr 11/68*  
DATE

*[Signature]*  
NAME OF AUTHORIZED INSPECTOR

**Eagle**  
**6-81 37**  
LIC. No. / STAMP

Details of outstanding work and other information on reverse.

MAINTENANCE RELEASE

**REMARKS**

(Details of work performed/reason for removal)

*Modified as per STC SH 92-54*

(Additional work to be performed upon installation)

INSTALLED ON

DATE

MAINTENANCE RELEASE

Date: Monday, 2/11/2008 2:14:35 PM  
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 37362  
 Estimate Number : 10877  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 36821  
 Written By :  
 Checked & Approved By : 2008 02 11  
 Comment : Est Rev: A 04.11.09 New issue KJJ/JLM

Drawing Name : VERTICAL REFERENCE DOOR  
 Part Number : D205711013  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material : N/A  
 Due Date : 3/14/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #. Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5671 to Eagle Copters

"Assembly of D205-711-013 Door Assembly

Send a copy of this IPP

C208/02/11 ①

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

LT08-003302

4.0 D412711101 Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

LT08-001222

5.0 D205711113 Wiring Harness, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

1 D205-711-113 Wiring Harness, 205

Attach servicable tags

Batch  
W/043667.11.1

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37302

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

EA2046915205

Instrument Panel, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 EA20469-15-205 Instrument Panel, 205 4644499

Attach serviceable tags

*[Handwritten signature]*

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door LT 08-003302

Attach serviceable tags

*[Handwritten signature]*

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window LT 08-001222

1 EA20469-05 Rubber Strip LT 06-011664

1 EA20469-06 Aluminum Strip Deleted

1 EA20469-07 Angle 4644499

1 EA20469-08 Placard 444499

1 EA20469-10 Rear Rib Assy 444499

1 EA20469-11 Angle 444499

1 EA20469-12 Fwd Rib 444499

1 EA20469-13 Window 444499

1 EA20469-14 Window Retainer 444499

1 EA20469-16 Armrest Assy 444499

1 EA20469-17 Angle 444499

1 EA20469-18 Door Inner Skin 444499

1 EA20469-21 Door Cover Panel 444499

2 EA20469-23 Link 444499

1 EA20469-24 Rod 444499

1 EA20469-25 Arm Assy 444499

Material Certification / Proof of Traceability / Certificate of Conformity required



Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37362

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description:

### 3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3A	Bolt	<u>07-18790</u>
22	AN3-4A	Bolt	<u>08-001209</u>
24	AN3-7A	Bolt	<u>07-017476</u>
6	AN960-6L	Washer	<u>05-022623</u>
90	AN960-10L	Washer	<u>06-018522</u>
34	CR3242-4-2	Rivet	<u>08-001645</u>
135	MS20426AD3-3	Rivet	<u>07-006985</u>
140	MS20426AD4-3	Rivet	<u>05-002460</u>
25	MS20470AD3-3	Rivet	<u>07-007189</u>
90	MS20470AD4-3	Rivet	<u>07-015056</u>
24	MS21042L3	Nut	<u>08-002039</u>
2	MS21042L06	Nut	<u>06-014775</u>
13	MS21069L3	Nut Plate	<u>08-001202</u>
8	MS21069L08	Nut Plate	<u>07-018940</u>
1	MS21071L3	Nut Plate	<u>08-002216</u>
1	MS21071L08	Nut Plate	<u>08-001935</u>
9	MS21075L3	Nut Plate	<u>05-004764</u>
2	MS24677-12	Screw	<u>05-011931</u>
6	MS27039-1-09	Screw	<u>07-014232</u>

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*[Signature]*

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



*[Signature]*

Comment: INSPECT WORK TO CURRENT STEP

# Eagle Copters Maintenance Ltd

## WORK REPORT

Work Order Number: 44503

V/Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.*

### Squawk: 2.1

#### Discrepancy:

Modify Door to Vertical Reference Door as per DART STC SH92-54 (Bell 205)

#### Resolution:

Vertical reference door modified iaw dart STC SH92-54 (bell 205) on service order P/O 081000838. Assembled door and installed window.

2.1 Work Done By: Richard Semeniuk

*The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*  
**AMO 6-81** Signature: Colin Gould on 4/9/2008

#### Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-125	L/H DOOR ASSEMBLY	LT-08-003302	Core	1
BELL212-L	BUBBLE WINDOW ILO	LT-08-001222	New	1
	EA20469-03 and			
	D412-711-101			
412-110-103	DOOR HANDLE W/LOCK	LT-08-003510	New	1
204-030-481-001	ROD ASSY	LT-08-004809	New	1
204-030-499-005	ROLLER ASSY	LT-08-004153	New	2
204-030-853-037A	SKIN ASSY	LT-08-004296	New	1
204-031-762-001	SPRING ASSY	LT-07-017524	New	2
204-031-762-002	SPRING ASSY	LT-07-011196.3	Inspected	1
204-031-762-002	SPRING ASSY	LT-07-011196.4	Inspected	1

#### Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

### Squawk: 2.2

#### Discrepancy:

Paint Door

#### Resolution:

Painted as required

2.2 Work Done By: Colin Gould

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

100

**MAINTENANCE RELEASE**

Date: Monday, 2/11/2008 2:14:35 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR  
 Job Number : 37362  
 Estimate Number : 10877  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 36821  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 04.11.09 New issue KJ/JLM

Part Number : D205711013  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material : N/A  
 Due Date : 3/14/2008 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5671 to Eagle Copters

"Assembly of D205-711-013 Door Assembly

Send a copy of this IPP

C208102111 ①

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0 D41271101 Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0 D205711113 Wiring Harness, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D205-711-113 Wiring Harness, 205

Attach serviceable tags

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37362

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915205

Instrument Panel, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 EA20469-15-205 Instrument Panel, 205 \_\_\_\_\_

Attach serviceable tags

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door \_\_\_\_\_

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window \_\_\_\_\_

1 EA20469-05 Rubber Strip \_\_\_\_\_

1 EA20469-06 Aluminum Strip \_\_\_\_\_

1 EA20469-07 Angle \_\_\_\_\_

1 EA20469-08 Placard \_\_\_\_\_

1 EA20469-10 Rear Rib Assy \_\_\_\_\_

1 EA20469-11 Angle \_\_\_\_\_

1 EA20469-12 Fwd Rib \_\_\_\_\_

1 EA20469-13 Window \_\_\_\_\_

1 EA20469-14 Window Retainer \_\_\_\_\_

1 EA20469-16 Armrest Assy \_\_\_\_\_

1 EA20469-17 Angle \_\_\_\_\_

1 EA20469-18 Door Inner Skin \_\_\_\_\_

1 EA20469-21 Door Cover Panel \_\_\_\_\_

2 EA20469-23 Link \_\_\_\_\_

1 EA20469-24 Rod \_\_\_\_\_

1 EA20469-25 Arm Assy \_\_\_\_\_

Material Certification / Proof of Traceability / Certificate of Conformity required

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37362

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt \_\_\_\_\_

22 AN3-4A Bolt \_\_\_\_\_

24 AN3-7A Bolt \_\_\_\_\_

6 AN960-6L Washer \_\_\_\_\_

90 AN960-10L Washer \_\_\_\_\_

34 CR3242-4-2 Rivet \_\_\_\_\_

135MS20426AD3-3 Rivet \_\_\_\_\_

140MS20426AD4-3 Rivet \_\_\_\_\_

25 MS20470AD3-3 Rivet \_\_\_\_\_

90 MS20470AD4-3 Rivet \_\_\_\_\_

24 MS21042L3 Nut \_\_\_\_\_

2 MS21042L06 Nut \_\_\_\_\_

13 MS21069L3 Nut Plate \_\_\_\_\_

8 MS21069L08 Nut Plate \_\_\_\_\_

1 MS21071L3 Nut Plate \_\_\_\_\_

1 MS21071L08 Nut Plate \_\_\_\_\_

9 MS21075L3 Nut Plate \_\_\_\_\_

2 MS24677-12 Screw \_\_\_\_\_

6 MS27039-1-09 Screw \_\_\_\_\_

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/11/2008 2:14:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 37362

Part Number: D205711013

< Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-711-013

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:35 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR  
 Job Number : 37362  
 Estimate Number : 10877  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 36821  
 Part Number : D205711013  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material : N/A  
 Due Date : 3/14/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 04.11.09 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

08.02.12

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_ to Eagle Copters

"Assembly of D205-711-013 Door Assembly

Send a copy of this IPP

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

REFERENCE ONLY

4.0 D412711101 Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0 D205711113 Wiring Harness, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D205-711-113 Wiring Harness, 205

Attach serviceable tags